

Date: Tuesday, 5/23/2006 8:13:03 AM
User: Kim Johnston

Process Sheet

SPLIT LL

Customer : CU-DAR001 Dart Helicopters Services
Job Number : 27168
Estimate Number : 11809
P.O. Number : N/A
This Issue : 5/23/2006 S.O. No. : N/A
Prsht Rev. : NC
First Issue : N/A Type : PURCHASED PARTS
Previous Run : N/A
Written By : See Comment Below
Checked & Approved By : 06-05-23
Comment : Est. B04 06.08 Reformat; Added Powder Coat KJ/JLM

Drawing Name : O-RING
Part Number : D25943
Drawing Number : D2594 REV B1
Project Number : N/A
Drawing Revision : B1
Material : N/A
Due Date : 6/2/2006 Qty: 5,000 Um: Each

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 PG PURCHASING



Comment: PURCHASING

Issue P/O: 1315
Purchase as per Dwg D2594
Possible P/N: Parker 2-011
Material release note is required

C206/05/24

5000

2.0 MS28775011 O-Ring



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5000.0000 Each(s)
O-Ring

3.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Recieve & Inspect for Transit Damage
Ensure Material Release Note is attached

06/06/06
969

4.0 QC6 DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

06-06-06
As per QSI 015

5.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock
Location: 5752

06/06/06 969

969

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector
		split - rec'd part 21				<i>u</i>	

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: *SD* Date: *20/06/07*

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

Date: Tuesday, 5/23/2006 8:13:03 AM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: O-RING

Job Number: 27168

Part Number: D25943

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

DC

DOCUMENT CONTROL



969

Comment: DOCUMENT CONTROL

Inspection Level 21

Handwritten: D 05/26/07

Job Completion



Handwritten: Ce Obale.07

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

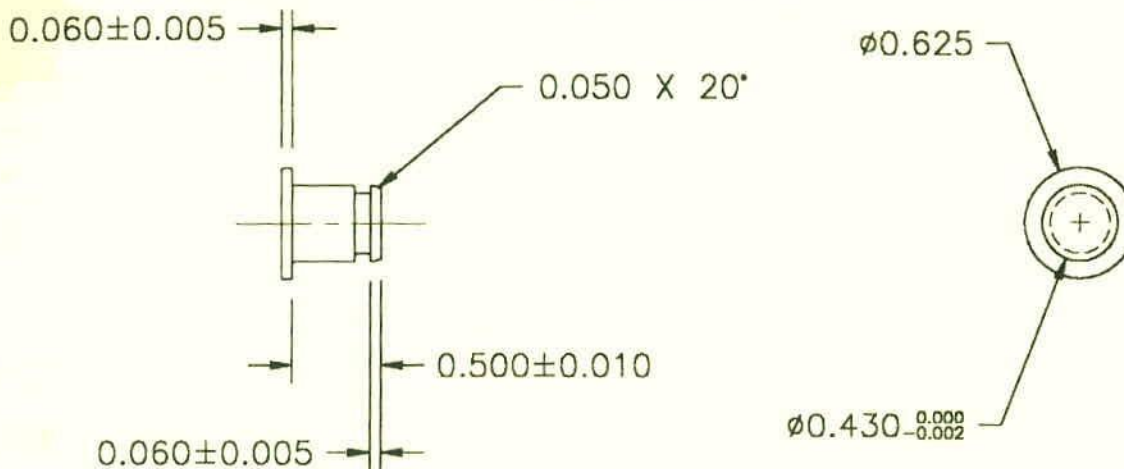
QA: N/C Closed: _____ Date: _____



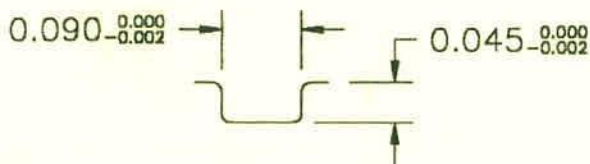
DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED <i>BW</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2594	REV. B SHEET 1 OF 1
DATE 96:09:16		TITLE PLUG	SCALE 1:1
B	97:03:15	ADD GROOVE AND O-RING	
B1	<i>RF</i> 02-08-26	ADD Powder Coat, QSI 018, & QQ-A SPECS.	

D2594-1 PLUG:

RELEASED
97/03/27 DS



GROOVE DETAIL (SCALE 5:1)



TOOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.

BREAK ALL SHARP CORNERS 0.010 MAX

MATERIAL: 5052-H32 OR 6061-T6 OR 1100-O

FINISH: ACID ETCH, ALODINE

POWDER COAT WHITE (REF. 43.5.1) PER QSI 005 4.3

PER QQ-A-225 / 7 (5052)
OR QQ-A-225 / 8 (6061)
OR QQ-A-225 / 1 (1100)
OR QQ-A-200 / 3 (6061)

D2594-3 O-RING: 5/16 ID, 7/16 OD, 1/16 WIDTH
(PARKER 2-011)

D2594 PLUG ASSEMBLY INCLUDES: (1) D2594-1 PLUG
(1) D2594-3 O-RING

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 27168



Parker Hannifin Corporation
 O-Ring Division
 P.O. Box 2276
 Brownsville, TX 78522
 Phone: (859) 335-3000

— NOTICE —
This is a C.B.I. Compound!

C.B.I. is Parker's exclusive quality assurance program for Controlled-Batch Identification, your assurance of reliability.

CONFORMANCE CERTIFICATE FOR MATERIAL SHIPPED

Parker O-Ring Division certifies that the material used in the manufacture of the parts identified below and called for on Purchase Order Number 130211 received by us from VALTEC INC is traceable to C.B.I. Number 80026579 and that the material used conforms to the requirements of the specifications indicated below. The tests were performed in accordance with these specifications, and data supporting the indicated results are on file.

CUSTOMER PART NUMBER	PARKER PART NUMBER	COMPOUND	QUANTITY	CURE DATE	SHIP DATE
MS26775-011 REV E	2-011	N0304 -75	15672	4Q04	04/15/05
TESTED AS: 2-214					
PHYSICAL PROPERTIES		REQUIREMENTS	VARIATION	PARKER FINDINGS	
SPECIFICATION MIL-P-25732C		TYPE	CLASS	TEST DT 11/05/04	
ASTMD297 SPECIFIC GRAVITY			(1.26 - 1.30)	1.2800	
ASTMD2240 HARDNESS SHORE A		(68 - 80)	(70 - 80)	76	
ASTMD1414 TENSILE STRENGTH, PSI		1350 MIN	(1440 - 2160)	1931	
ASTMD1414 ELONGATION, %		160 MIN	(160 - 226)	218	
MODULUS AT 100% ELONG.		500 MIN	(500 - 9999)	617	
TR-10 50% ELONG. 10% RETURN		-49 MAX		-54.0	
FLUID AGEING 70 HRS AT 275F IN MIL H-5606					
ASTMD395 COMPRESSION SET % MAX		55		35.6	
TR-10		-49 MAX		-52.0	
ASTMD2240 HARDNESS CHANGE		+5 -15		-12.0	
VOLUME CHANGE		1 +20		18.6	

Handwritten signature and "P/O 1315" stamp are visible over the table.

RECEIVED

APR 28 2005

INSPECTOR 7

No Mercury, Mercury compounds or Mercury bearing instruments, equipment or apparatus which might cause contamination has been used in the manufacture or subsequent processing of material covered by this order.

Purchaser use only. Reproduce only in full. Data pertains to items referenced.

The recording of false, fictitious or fraudulent statements or entries on the certificate may be punishable as a felony under federal law.

The information contained herein is submitted as the privileged and confidential property of the Parker Hannifin Corporation pursuant to 5 U.S.C. Section 552 (b)(3) and (b)(4), the Freedom of Information Act, exemption Number 3 and Number 4. This information shall not be duplicated, used or disclosed in whole or in part outside the recipient organization without express written consent of the Parker Hannifin Corporation.

**O-Ring Division
 PARKER HANNIFIN CORPORATION**

By

Ruben Ramirez
 Quality Assurance Manager



API
2461 46th Ave.
LACHINE QC H8T 3C9
CANADA



Page 1 of 1
05/29/2006 09:31:52

Delivery Note

Shipping Address

DART AEROSPACE LTD.
1270 ABERDEEN STREET
HAWKESBURY ON K6A 1K7
CANADA

Forwarding Agent's Address

Shipping Instructions

Detailed Shipping Instructions at the
end of the document

Packing Instructions

Detailed Packing Instructions at the
end of the document

Information

Document Number	80068304
Document Date	05/29/2006
Purchase Order No.	PO00001315
Purchase Order Date	05/25/2006
Sales Order Number	63634
Sales Order Date	05/25/2006
Customer Number	6100481
Shipping Conditions	FXPri 1D (Intl 1-3D)
Incoterms	
Cust Ship Acct	
Delivery Date	05/31/2006
Bill of Lading	
Total Weight	2.907 LB
Total Volume	0.969 IN3

Item	Material	Material Description	Quantity	Weight	Batch Num
10	MS28775-011	PACKING			
	Batches				
	1140410719	969.000 EA	2.907 LB	LOC: 001	1103-09-00
Shipping and Packing Instructions					
<div>Rec'd 9711</div> <div>06/06/01</div> <div></div>					

CERTIFICATE OF CONFORMANCE

I hereby certify that the aircraft parts described hereon were acquired from a source of supply that is consistent with the conditions under which Transport Canada distributor approval number 77-98 has been granted.

Authorized Signature

Rw

AO # 77-98
API # 11

